

Date: Thursday, 1/25/2007 10:24:46 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING ANGLE
Job Number	: 30464		
Estimate Number	: 10509		
P.O. Number	: N/A	Part Number	: D2564
This Issue	: 1/25/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2564 REV. B1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27709	Drawing Revision	: B1
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 2/17/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	50 Um: Each
Comment	: Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6207	Angle Extrusion 1x1x.125
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Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s)
Angle Extrusion
Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)
(D6207) Batch: M27538

J.L 07/02/19 51

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

J.L 07/02/19 51

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA276 and Dwg D2564
Tumble and Deburr
Identify as D2564

J.L 07/02/23 51

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/02/23 51

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/02/23 51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 07/02/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:24:47 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING ANGLE

Job Number: 30464

Part Number: D2564

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5

PC 7/2/26 51

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(51)

Comment: FINAL INSPECTION/W/O RELEASE

207/02/27

Job Completion



U 87-0227

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

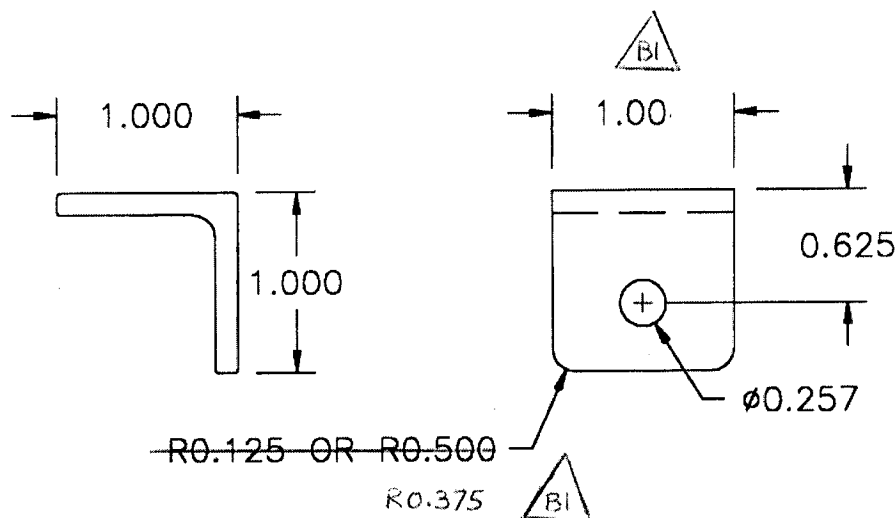
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. B
CHECKED	APPROVED	D2564	SHEET 1 OF 1
BW	BW		
DATE	TITLE	SCALE	
96:04:30	MOUNTING ANGLE	1:1	
B	97:05:06	MODIFIED DIMENSIONS	
BI	02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000	

RELEASED
97/05/06 BW



NOTES:

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 - 0.015
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30464